

Date: Tuesday, 29/07/2008 9:05:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/b6
d/j

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.26

Date: Tuesday, 29/07/2008 9:05:12 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D344013 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

batch:- 324013B

✓ - ✓ - ✓ 08.08.07 3

14.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

ensure no burn thru after welding in tube -235 and -229

08.08.06

✓ - ✓ - ✓ 08.08.07

3

15.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pd 08.08.08 (3)

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (3)

17.0 POWDER COATING POWDER COATING



M102316

3X

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

8:15

START TIME:

320 01

OVEN TEMPERATURE:

8:45

FINISH TIME:

m. l

08/08/11

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11

X 3

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

99952

Date: Tuesday, 29/07/2008 9:05:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:- 340777

12 08.07.31

7.0 PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:- 340779

12 08.07.31

8.0 PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Flanged Hook

batch:- 340040

12 08.07.31

9.0 PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Restraint

batch:- M19695

12 08.07.31

10.0 PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Contoured Hinge Arm

batch:- 340059-1 340059-3

12 08.07.31

11.0 PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Handle Arm Extension

batch:- 340044

12 08.07.31

12.0 D34409

Tube Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Detent Clip Base

batch:- 323936

12 08.07.31

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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT BLADE FOLD ASSY WELDMENT		
Job Number	: 40772			Part Number	: PB674300109		
Estimate Number	: 13503			Drawing Number	: B6743001 P.6		
P.O. Number	:			Project Number	: N/A		
This Issue	: 29/07/2008	S.O. No.	:	Drawing Revision	: B1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 05/08/2008		
Previous Run	:			Qty:	3		
Written By	:			Um:	Each		
Checked & Approved By	: <u>DMT 08-07-29</u>						
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description	
1.0	PB6743001211	Square Tubing	
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)	
		Square Tubing batch: <u>340596</u>	
2.0	PB6743001209	Square Tubing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Square Tubing batch: <u>340595</u>	
3.0	PB6743001201	Square Tubing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Square Tubing batch: <u>340592</u>	
4.0	PB6743001203	Square Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Square Tube batch: <u>340594</u>	
5.0	PB6743001239	Square Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Square Tube batch: <u>340555</u>	